

ASTALAC™ ABS M112P

Acrylonitrile Butadiene Styrene

Marplex Australia Pty. Ltd.

Message:

ASTALAC™ ABS M112P is an ultra high heat resistance grade of ABS designed to enhance the surface adhesion of decorated automotive interior components. The grade features an exacting balance of heat resistance, impact toughness, product rigidity and mouldability with typical applications in the automotive area including console capping mouldings and instrument panel fascias.

Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTALAC™ ABS M112PUV].

General Information			
Features	Good Impact Resistance		
	Good Moldability		
	High Heat Resistance		
	Medium Rigidity		
Uses	Automotive Applications		
	Automotive Instrument Panel		
	Automotive Interior Parts		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
220°C/10.0 kg	5.0	g/10 min	
230°C/3.8 kg	2.0	g/10 min	
Molding Shrinkage - Flow (3.00 mm)	0.60	%	ASTM D955
Water Absorption (24 hr)	0.25	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	52.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	45	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2450	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	75.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	150	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	90.0	°C	
1.8 MPa, Unannealed, 6.40 mm	96.0	°C	
1.8 MPa, Unannealed, 12.7 mm	105	°C	
Vicat Softening Temperature	118	°C	ASTM D1525 ⁵

CLTE - Flow	6.5E-5	cm/cm/°C	ASTM D696
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Glow Wire Ignition Temperature (1.60 mm)	550	°C	AS/NZS 60695.2.12
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 95.0	°C	
Drying Time	3.0 to 6.0	hr	
Rear Temperature	215 to 235	°C	
Middle Temperature	225 to 245	°C	
Front Temperature	235 to 255	°C	
Processing (Melt) Temp	230 to 260	°C	
Mold Temperature	40.0 to 80.0	°C	
Injection Pressure	60.0 to 140	MPa	
Injection Rate	Moderate		
Back Pressure	0.100 to 0.500	MPa	
Screw Speed	40 to 60	rpm	
Clamp Tonnage	3.0 to 6.0	kN/cm ²	
NOTE			
1.	5.0 mm/min		
2.	5.0 mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		
5.	Loading 1 (10 N)		

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